

Work Order ID 50527

July 14, 2009 8:54:10 AM



Page 1

Item ID: D3789-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 14/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00



Customer:

Reference:

Handwritten signature and date: 14-07-14

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



Bandsaw

Memo

0.00

(B43722)

*mmf
09/07/15*

7

Jeaspa Bandsaw

Cut extrusion to .820"

110

0.00



HAAS 1

Memo

0.00

7

HAAS CNC vertical machine #1

Machine as per Folio FA834

Dwg Rev: *A*

Folio Rev: *AA*

*mmf
09/07/15*

Deburr

Work Order ID 50527

July 14, 2009 8:54:10 AM



Page 2

Item ID: D3789-5

Accept



Setup Start



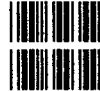
Revision ID: A

Stop



Item Name: Clamp

Start Date: 14/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/07/2009 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mw 09/07/15

7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DJ 09/07/15

7

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JH 09-07-16

7

DART AEROSPACE LTD		Work Order: 50527
Description: Clamp		Part Number: D3789-5
Inspection Dwg: A	Rev: AA	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	.03	4.20	✓			
3.45	.03	3.45	✓			
1.50	.03	1.50	✓			
.41	.03	.41	✓			
.40	.03	.39	✓			
.53	.03	.52	✓			
.750	.03	.75	✓			
.38	.03	.37	✓			
Ø .258	+ .005 - .000	Ø .258	✓			
R 1.47	.03	R .	✓			
R .38	.03	R .38	✓			
R .34	.03	R .34	✓			
R .20	.03	R .20	✓			
R .06	.03	R .06	✓			
R .03	.03	R .03	✓			
1.00 x 45°	± .010 x 1/2°	.98 x 45°	✓			

Measured by: m	Audited by: DJD	Prototype Approval:	N/A
Date: 09/07/15	Date: 09/07/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

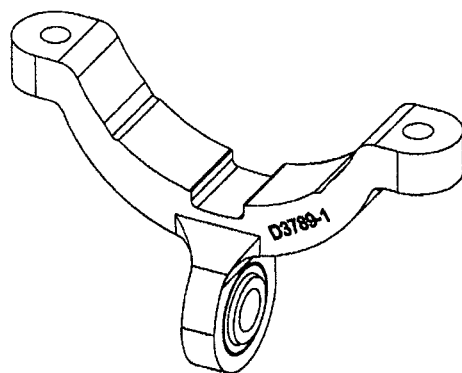
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

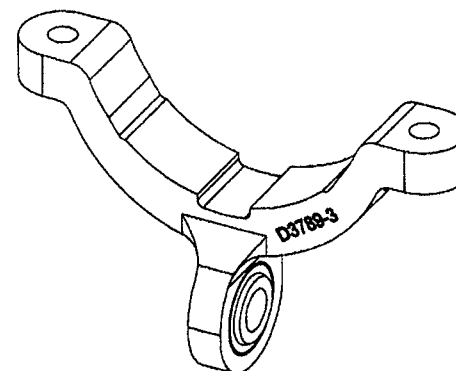
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

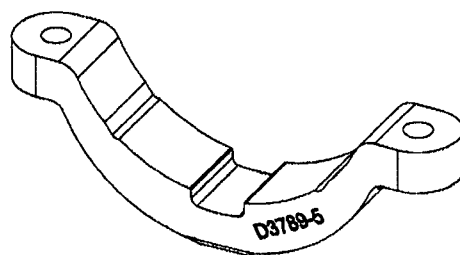
NOTE: Date & initial all entries



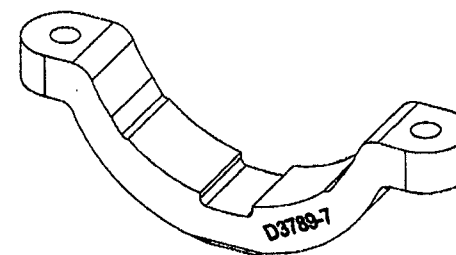
D3789-1 CLAMP



D3789-3 CLAMP



D3789-5 CLAMP



D3789-7 CLAMP

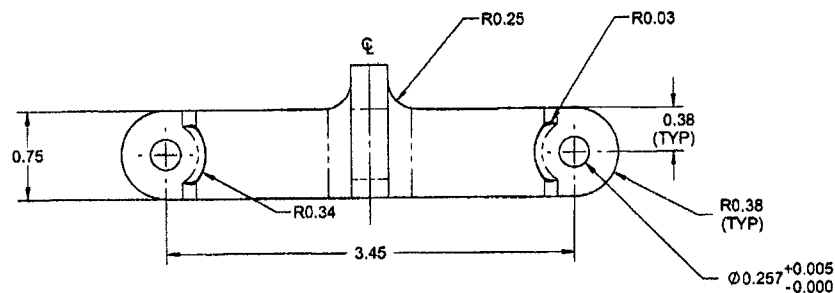
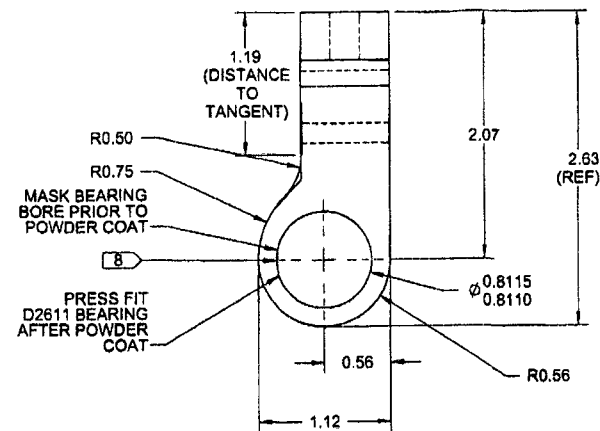
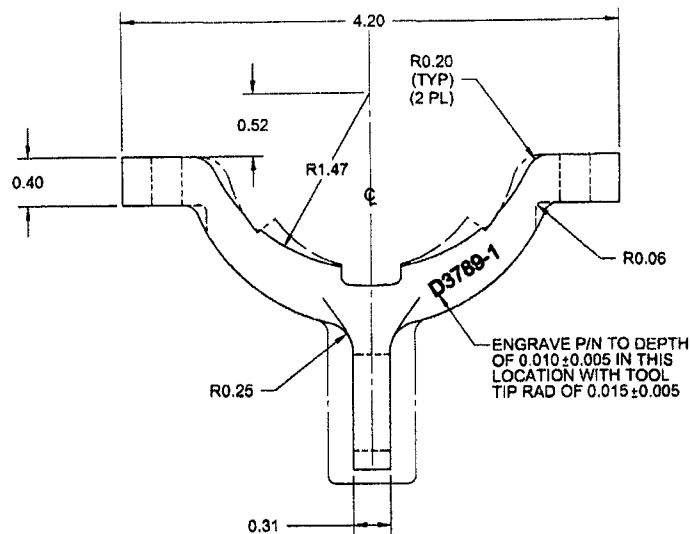
DEO ATTACHED

RELEASED
08/12/21

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMMETRICAL ABOUT ϕ




A NEW ISSUE		HS	08.05.21
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO D3789	REV. A
MFG. APPR.			SHEET 1 OF 5
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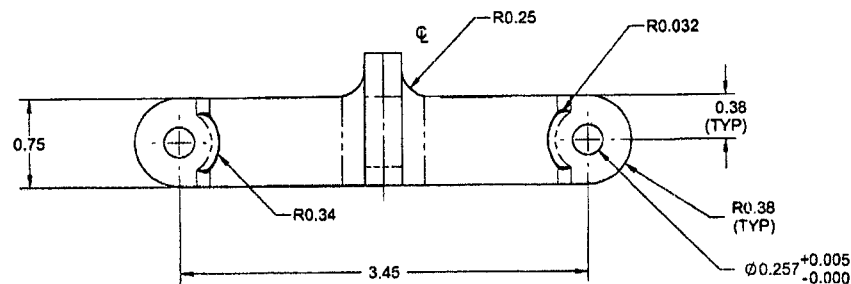
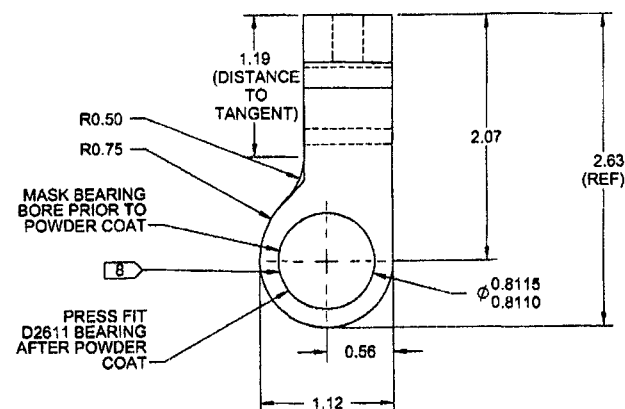
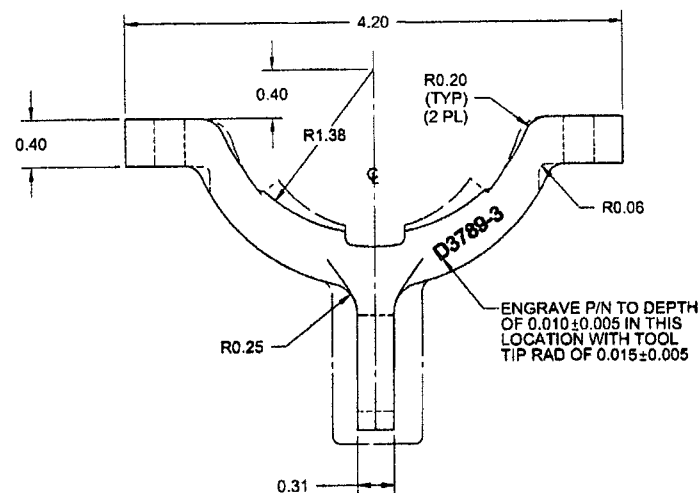


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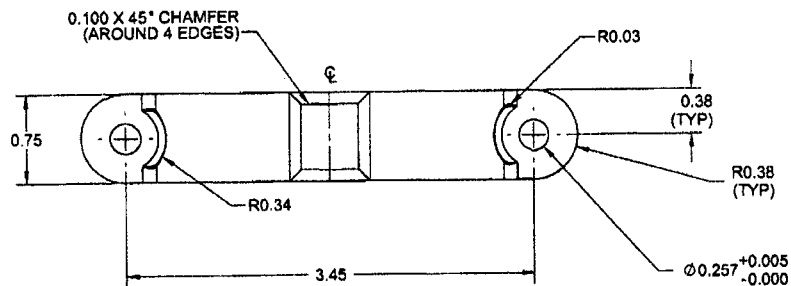
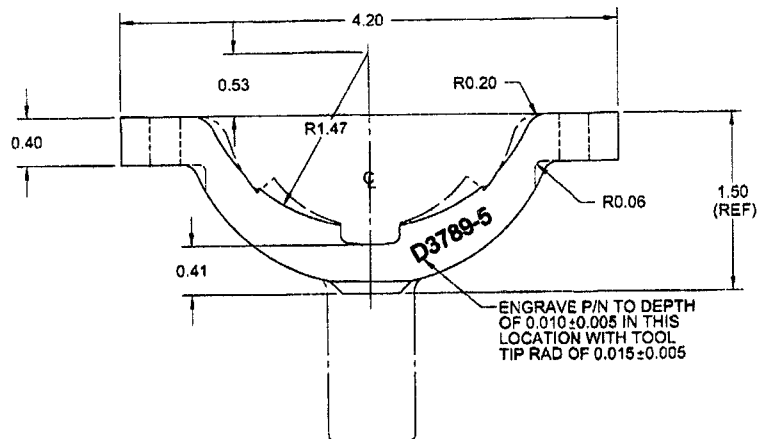


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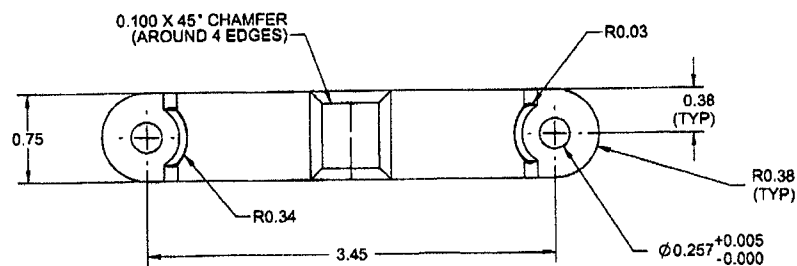
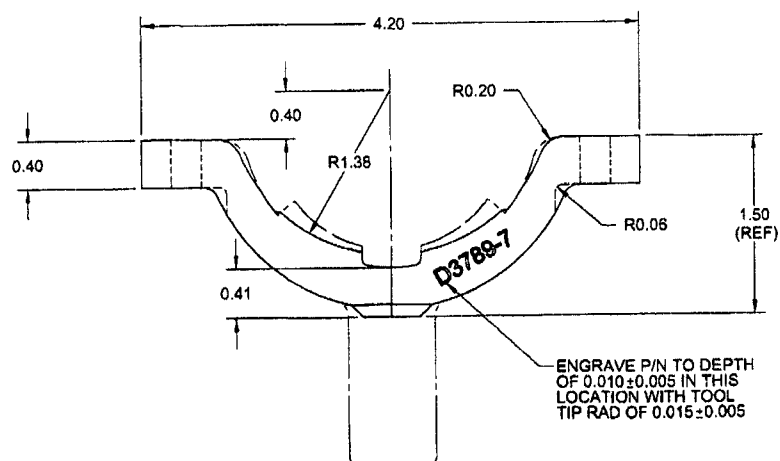


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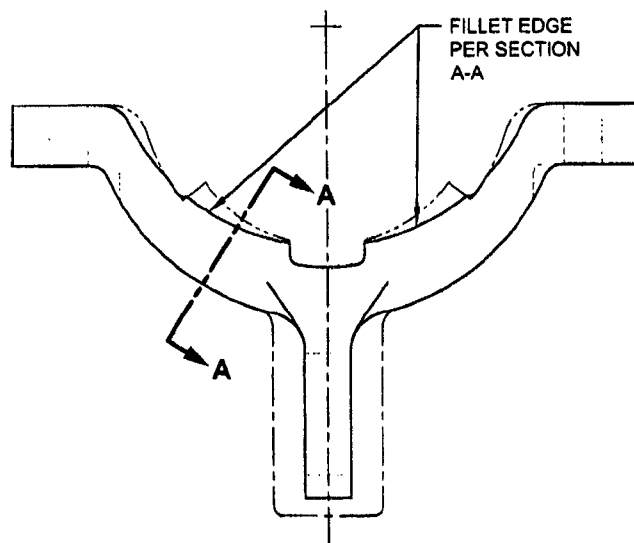
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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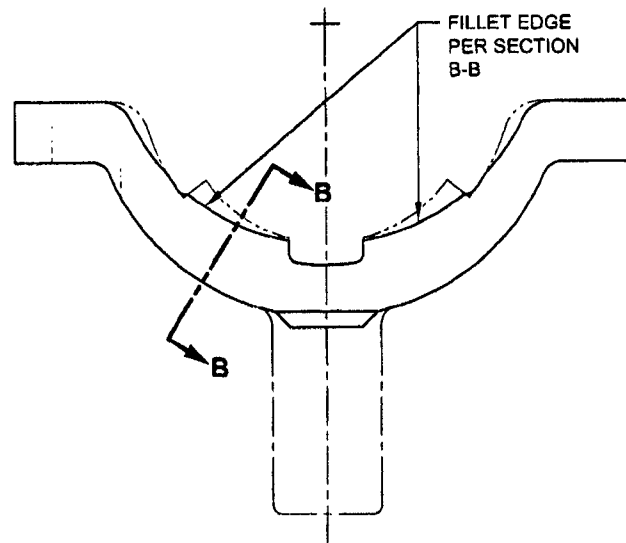
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DRAWN AJS	CHECKED b	MFG. APPR. [Signature]	APPROVED [Signature]	DE APPR. [Signature]		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



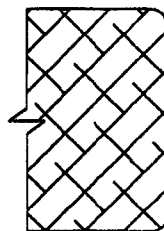
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

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09/05/04 [Signature]

SEE PAR 122 FOR FURTHER DETAILS

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